Work Order ID Tuesday, February 01, 20			1					-	Page 1
Item ID: D3538-1 Revision ID: Item Name: Hinge Bra	104//	Accept				S	Setup Sta		
Start Date: 2/1/2011 Required Date: 2/7/2011 Reference:	Start Qty: 12.00 1		Cust Iter Custome						(818 1181) 3861
	Date:	//-02-/ Tooling SPC (Y		Date:		F	Run Sta		
Sequence ID/ Work Center ID	Operation Description	Set U Run	Up/ Tool II Hours	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	Revision Nbr Rev A								
100 	BAND SAW Memo Cut blanks 1.500" long	0.00	orl 1/03/03			24	P		
110 	HAAS CNC VERTICAL MACHININ Memo 1 1-Machine as per Folio F.	0.00	-Deburr	74	(24)	,	<u>.</u>
	QC2- Inspect parts off machine FAI/F	AIB 0.00	JL 11/03/07		ł	<i>7</i> 4	d		

Quality Control

Memo

0.00

Dari Ae	ospace	Liu								•-
W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	PROC	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
	R	esolution:	_ Dispositio	on:		A: N/C C	osed:		Date: _	
NCR:		W	ORK ORE	DER NON-CONFO	RMAN	CE (NCF	?)			
		Description of NC	Corrective Action		Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign of Date	k Sect	ion C	Chief Eng	QC Inspector
								,		
		-4								
					•					

Work Order ID 66018

Tuesday, February 01, 2011 3:51:51 PM



Page 2

Item ID:

D3538-1

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Required Date: 2/7/2011

Hinge Bracket

2/1/2011

Start Oty: 12.00

Reg'd Oty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Run

Start

Stop



Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

130

Operation

OC8- Inspect parts - second check

Set Up/ Run Hours

Tool ID

Tool # Plan Code Qty

Reject Accept Otv

Reject Number

Insp. Stamp

Quality Control

Description

Memo

0.00

0.00

140

HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

Memo

0.00

0.00

24 BR 11-3-8

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

24, Bl 11-3.8.

Dart Aero	space	Ltd
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W/O:			W	ORK ORDER CHANG	SES					
DATE	STEP	PRO	PROCEDURE CHANGE			D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	<u> </u>	PAR #:	Fault Cat	egory:	NCR: Y	es No	DQA:		Date:	
		esolution:								
NCR:			WORK ORE	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	tion B	gn &	Verificat		Approval	Approval
		Section A	Chief Eng	Chief Eng	D	ate	Section	C	Chief Eng	QC Inspector
i i										
						1				

Work Order ID 66018



Page 3

Item ID:

D3538-1

Tuesday, February 01, 2011 3:51:51 PM

Accept

Setup Start

Stop



Revision ID:

Start Date:

Hinge Bracket **Item Name:**

Required Date: 2/7/2011

2/1/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____

Date:_____

Tooling:

Date:

Run

Start



Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Memo

0.00

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

170

Packaging

Packaging

Identify as per dwg & Stock Location: 0 66

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Disposition	:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCF	R)			
		Description of NC	Corrective Action Se			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
		}							
	1							1	

Picklist Print

Tuesday, February 01, 2011 3:51:58 PM

Work Order ID: 66018

Parent Item: D3538-1

Parent Item Name: Hinge Bracket

Start Date: 2/1/2011

Required Date: 2/7/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-10.03 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25		Purchased	No		100	f	24.9275	0.19	2.4			

110001



6061-T6 Bar 1.25 x 1.25

Location	Loc Oty	Loc Code
MAT	17.633	
116135	17.633	
MAT03	7.294450526	
106259	7.06921053	

0.22524

23.0 and 11/03/03

D uit 7.01	OSPACE	Liu						
W/O:			WO	RK ORDER CHANGE	S			
DATE	STEP	PRO	CEDURE CHAI	IGE	Ву	Date Qt	y Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Re	esolution:	Disposition	n:	QA: N/C Clo	sed:	Date: _	
NCR:		`	WORK ORDE	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section	n B Sign &	 Verificatio		Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector
	!						Ì	

DART AEROSPACE LTD	Work Order:	44018
Description: Hinge Bracket	Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.750			Nem JL-3	,
0.375	+/-0.010	.345			٠.	
0.241	+/-0.010	.242				
0.830	+/-0.010	.830				
Ø0.172	+0.005/-0.001	. 143				
Ø0.400	+0.006/-0.001	-400				
0.031	+/-0.010	.029				
1.31	+/-0.030	1.311				
0.375	+/-0.010	.375				
0.99	+/-0.030	- 987				
0.125	+/-0.010	-125				
R0.19	+/-0.030	-187				
0.083	+/-0.010	.084				
93°	+/-0.5°	930	/			
0.674	+/-0.010	671			4G	
R0.38	+/-0.030	3.75				
Ø0.172	+0.005/-0.001	-173				

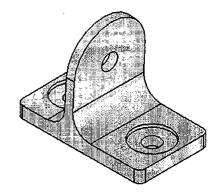
Measured by:	Sh	Audited by:	B. A	Prototype Approval:	N/A
Date:	11/03/07	Date:	11 03 07	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.05.31	New Issue	KJ/JLM	

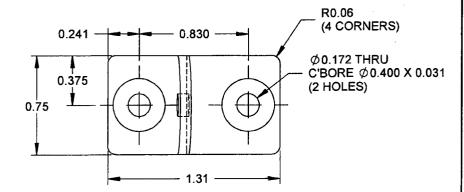
W/O:			WO	RK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHAN		By Date Qty Chief Eng				Approval Chief Eng / Prod Mgr	Approvar
									Prod Wigi	
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Y	es N	o DQ	A :	_ Date: _	
	Res	olution:	Disposition	QA: N/C Closed:				Date:		
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)			-	
DATE	CTED	Description of NC	Corrective Action Section			Verit		ication	Approval	Approval
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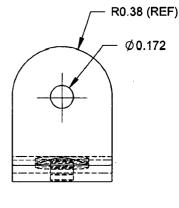


DESIGN DRAWN BY			DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECK	ŒD	APPROVED	DRAWING NO.	REV. A
P	H	一根	D3538	SHEET 1 OF 2
DATE			TITLE	SCALE
06.10.13			HINGE BRACKET	1:1
REV		DATE	DESCRIPTION	
Α		06.10.13	NEW ISSUE	

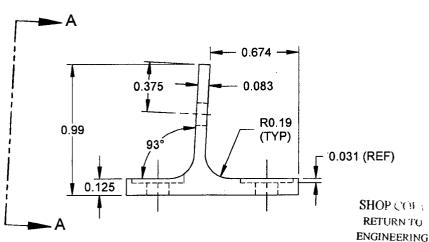


RELEASED





AUXILIARY VIEW A



D3538-1 HINGE BRACKET

UNCONTROLLED COL

SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

Pl11-02/

NOTES:

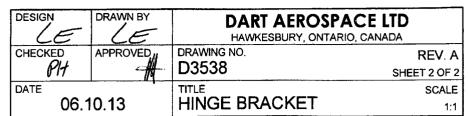
- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 ÚNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

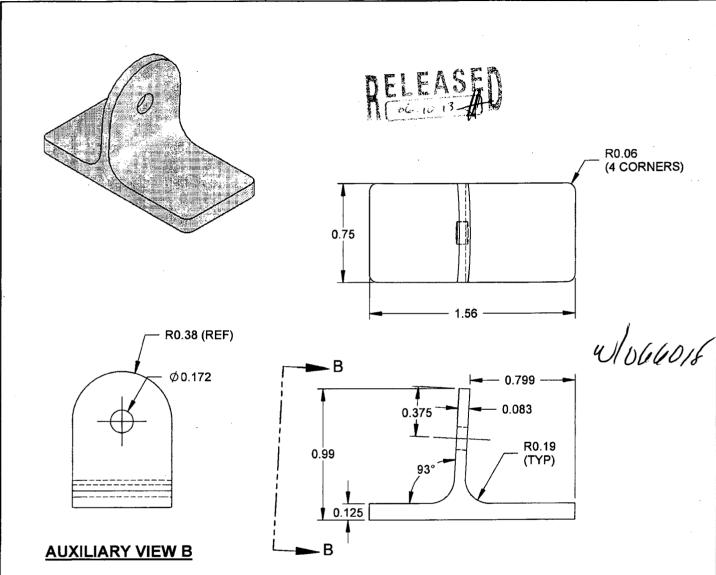
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W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date:		
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NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NC	R)				
DATE	STEP	Description of NC			tion B	verifica		Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector	
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NOTES

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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D3538-3 HINGE BRACKET

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Dail AcidSbace Liu	Dart	Aerospa	ace Ltd
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W/O:			WO	RK ORDER CHANG	ES	····			
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		V	WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
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